

Work Order ID 69589-1

Thursday, May 12, 2011 2:38:30 PM

Split

Ship Today



Page 1

Item ID: D3372-041

Accept



Setup Start



Revision ID:

Item Name: Collective Lock Assembly

Stop



Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date: 11/05/24 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-1 using A145-42A bolt as per Dwg D3372 Identify as D3372-3

110

QC5- Inspect part completeness to step on W/C

0.00



QC

Memo

0.00

Quality Control

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Disassemble the rest.  
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

EP 11/05/24  
EP 11/05/24

SB 11/05/24  
SB 11/05/24

SB 11/05/24  
SB 11/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

NOTE: Date & initial all entries

# Work Order ID 69589

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Item ID: D3372-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Collective Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Assemble D3372-053 as per Dwg 103372 Apply a drop of permanent lockite 262 to the threads

SB 11/05/24

Qty Part Number Description Batch  
A/R N/A Lockite 262 H13.434

Identify as D3372-053

2-Assemble 103372-054 as per Dwg



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Tack weld lock shaft as per Dwg 103372  
A/R SS Rod Batch 115928

H 11-05-24  
H 11-05-24

3

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 69589

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Item ID: D3372-041

Revision ID:

Item Name: Collective Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00

Required Date: 5/20/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

QC9- Inspect visual per QS4004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

ECR-05-24

160

QC5- Inspect part completeness in step on WFO

0.00



QC

Memo

0.00

Quality Control

5/16/24

(H)

170

Identify as per dwg & Stock Location 193

0.00



Packaging

Memo

0.00

Packaging

11/5/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Work Order ID 69589

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Item ID: D3372-041

Revision ID:

Item Name: Collective Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00

Required Date: 5/20/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

180



QC

Quality Control

Operation

Description

QC31-Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

11/5/24  
mf  
11-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 69589

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly



Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM  
IPP Rev:B Added Key ID 06.03.21 EC  
added D3384-043 DD 10.05.13 verified JLC

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16Wt SS Flat Washer 5/16 WS16S1		Purchased	No			100	Each	3387.000	2	2		5/11/05/24	

## Location

## Loc Qty

## Loc Code

ST376  
117332  
ST377  
115072  
115174  
116643

2000  
1487  
100  
65  
1222

ANS-42A

Purchased

No

100

Each

23.000

5/11/05/24

## Location

## Loc Qty

## Loc Code

ST341  
108442

26  
26

AN960-416

NAS114910463P

Purchased

No

100

Each

0.0000

2

2

5/11/05/24

Washer

D2728-7

Manufactured

No

100

Each

0.0000

0

0

5/11/05/24

Dart Lock Label

D3372-1

Manufactured

No

100

Each

0.0000

1

1

5/11/05/24

Main Body

B 69 621

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Work Order ID: 69589



Parent Item: D3372-041



Parent Item Name: Collective Lock Assembly

Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3372-5  
  
 Cam Lock Shaft

Manufactured No

100 Each

5

1



80 11/05/24

Location

Loc Qty

Loc Code

ST048

5

59557

5

D3372-7  
  
 Slider Body

Manufactured No

100 Each

1,0000

1



80 11/05/24

Location

Loc Qty

Loc Code

ST485

1

58439

1

D3373-1  
  
 Cam Lock

Manufactured No

100 Each

20.0000

1



80 11/05/24

Location

Loc Qty

Loc Code

ST049

20

58463

20

D3384-043  
  
 Cyclic Lock Assembly

Manufactured No

100 Each

0.0000

1



80 11/05/24

HX-81  
  
 1/4"-20 SHCS 3/8" long

Purchased No

100 Each

33.0000

1



80 11/05/24

Location

Loc Qty

Loc Code

ST390

33

114383

33

80 11/05/24

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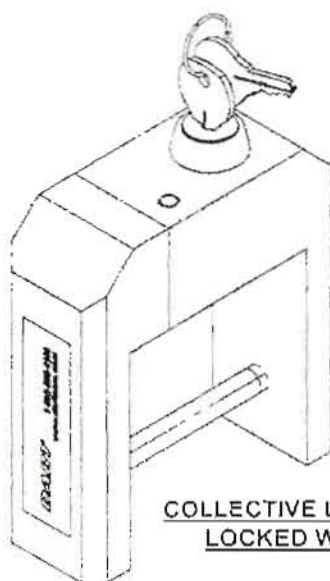
Shop Packet Print

Page 2

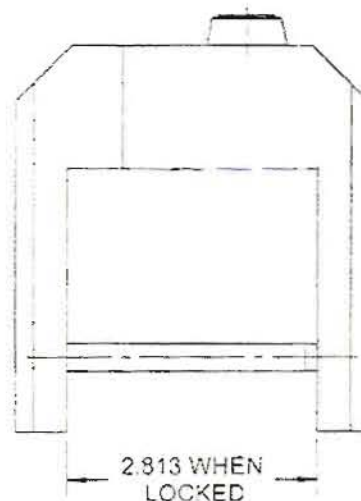




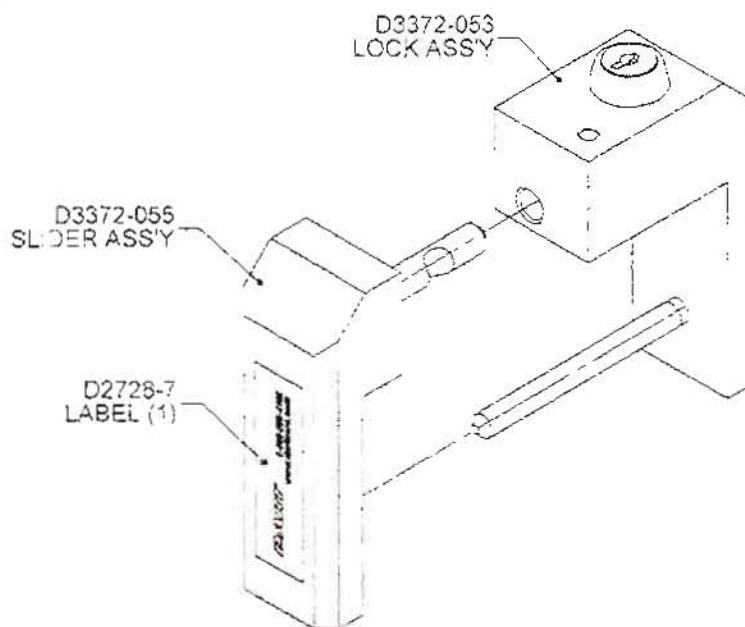
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CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS



2.813 WHEN  
LOCKED



D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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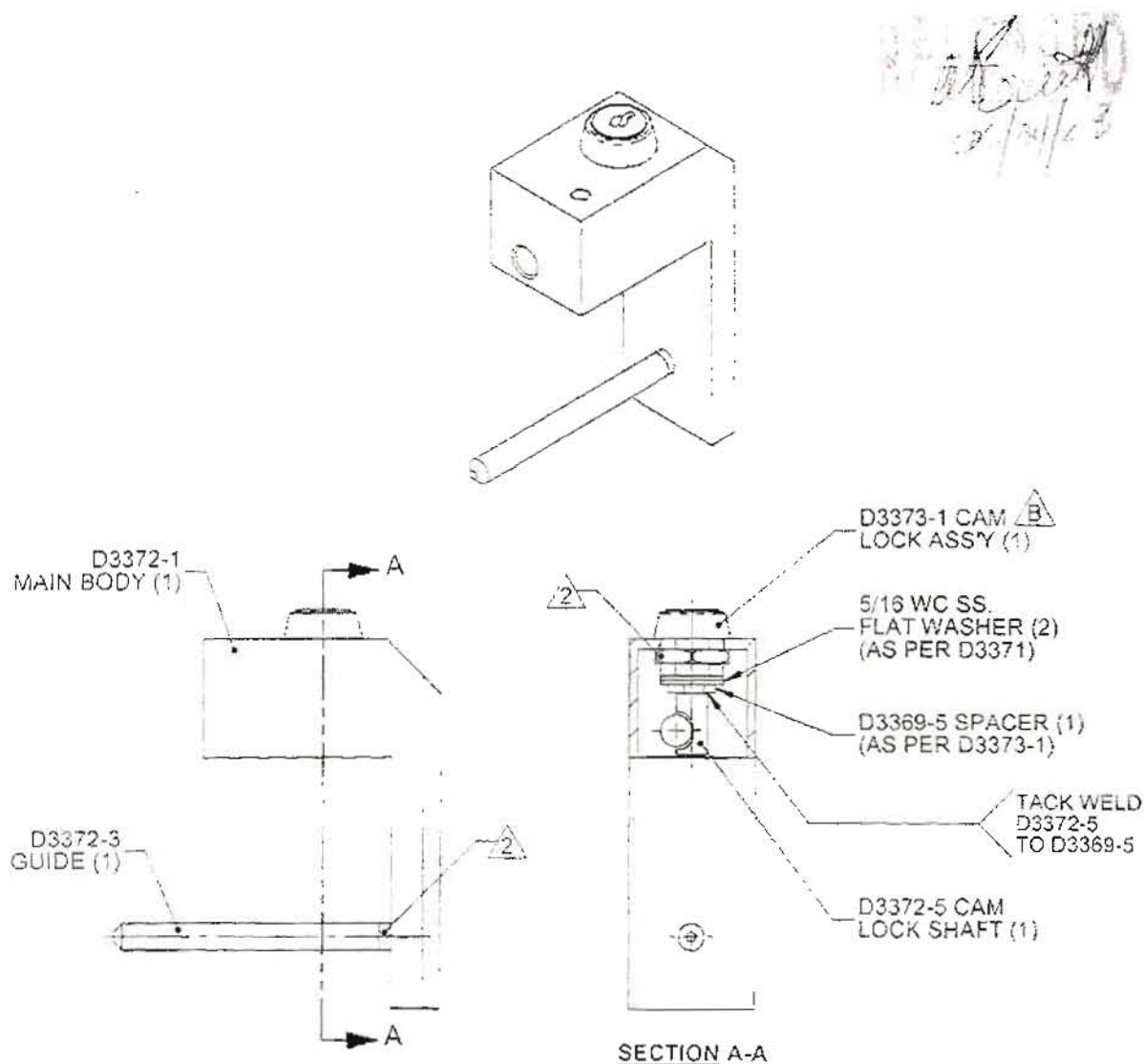
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CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



### D3372-053 LOCK ASS'Y

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

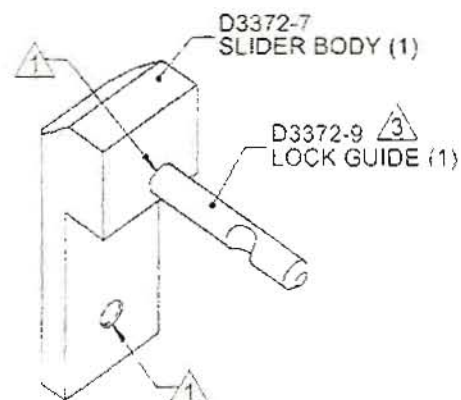
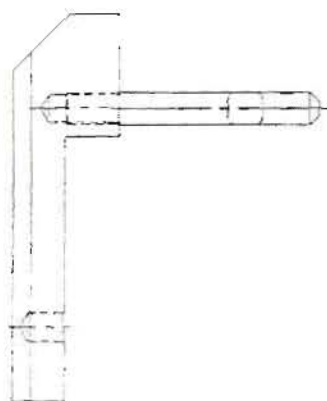
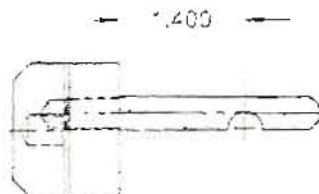
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CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2



### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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